

Work Order ID 160912

Friday, May 05, 2017 9:44:45 AM

160912

Page 1

Item ID: PB67-43001-09 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Blade Fold Assembly Weldment
 Start Date: 5/8/2017 Start Qty: ~~7.00~~ ^{DAS 21 9-89} ***7*** Cust Item ID:
 Required Date: 6/20/2017 Req'd Qty: ~~7.00~~ ***7*** Customer:
 Reference: SCHEDULED/U

Approvals: Process Plan: ^{DAS 21 9-89} Date: **MAY 05 2017** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-09	E

100 Weld per dwg A/R Aluminum rod Batch: **131562** ^{DAS 24 9-89} **2** **JUN 14 2017** ^{DAS 24 9-89}
 Large Fab
 Memo 4.27
 1- Assemble parts on jig DT8814 and weld as per dwg PB67-43001

** Ensure no burn thru after welding in tube -235 and -229 only where bushing - 265 ***

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00
 Quality Control **17-06-14 PD**

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
JDS 8146								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																				
OTHER : _____																									

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Page 2

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 Revision ID: Stop ***NS2***
 Item Name: Aft Blade Fold Assembly Weldment
 Start Date: 5/8/2017 Start Qty: 7.00 ***7*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.14							
Quality Control									
130	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
130									
Powdercoat	Memo <i>M134092</i>	2.48							
Powder Coating	***MASK ALL OPENING AND INDICATED AREAS PRIOR TO POWDERCOATING, SEE NOTE 9 SHEET 2-3****								
	START TIME: <i>8:20</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>8:50</i>								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.07							
Quality Control									

2 17-0614 PD

2 17-0615 DS 34 9:89

2

38

JUN 15 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: WA3	0.00							DAS
150						2	JUN 1 5 2017		24
Packaging	Memo	0.07							9-89
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.70							
Quality Control									

17/6/2017

JUN 20 2017

DAS
21
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

Friday, May 05, 2017 9:44:45 AM

Page 1

Work Order ID: 160912

160912

Parent Item: PB67-43001-09

PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 5/8/2017

Required Date: 6/20/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec IPP RevB
10.09.24 per revC dwg EC verified by:DD IPP REV:C 14.12.15
AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-203W		Manufactured	No			100	Each	0.0000	1	7			
✓ *PR67-43001-203W*									**	3160942 → 2		JUN 13 2017	DAS 24 9-89
Square Tube Weldment													
PB67-43001-229W		Manufactured	No			100	Each	0.0000	1	7			
✓ *PR67-43001-229W*									**	3160944 → 2		JUN 13 2017	DAS 24 9-89
Outer Tube Weldment													
PB67-43001-239W		Manufactured	No			100	Each	0.0000	1	7			
✓ *PR67-43001-239W*									**	3160935 → 2		JUN 13 2017	DAS 24 9-89
Square Tube Weldment													
PB67-43001-201		Manufactured	No			100	Each	1.0000	2	14			
✓ *PR67-43001-201*									**			JUN 13 2017	DAS 24 9-89
Square Tube													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz2		1							
					152073	1							
PB67-43001-209		Manufactured	No			100	Each	0.0000	1	7			
✓ *PR67-43001-209*									**	3160824 → 2		JUN 13 2017	DAS 24 9-89
Square Tube													
PB67-43001-211		Manufactured	No			100	Each	6.0000	6	42			
✓ *PR67-43001-211*									**			JUN 13 2017	DAS 24 9-89
Square Tube													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz2		6							
					152092	6							
										3160828 → 12			

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
10/15/91 10:11 AM 10/15/91 10:11 AM 10/15/91 10:11 AM 10/15/91 10:11 AM				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Friday, May 05, 2017 9:44:45 AM

Page 2

Work Order ID: 160912

160912

Parent Item: PB67-43001-09

PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 5/8/2017

Required Date: 6/20/2017

Start Qty: 7.00

Required Qty: 7.00

✓ PB67-43001-213 Manufactured No

100 Each

1.0000

2 14

PR67-43001-213

Flanged Hook

**

JUN 13 2017

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

1

139200

1

100

Each

0.0000

1 7

PB67-43001-235

Manufactured No

PR67-43001-235

Outer Tube

**

JUN 13 2017

DAS
24
9-89

PB67-43001-243

Manufactured No

100

Each

1.0000

1 7

PR67-43001-243

Tube Handle Extension

**

JUN 13 2017

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

1

139196

1

100

Each

3.0000

1 7

PB67-43001-277

Manufactured No

PR67-43001-277

Contoured Male Eye

**

JUN 13 2017

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

3

148792

3

100

Each

1.0000

2 14

PB67-43001-311

Manufactured No

PR67-43001-311

Restraint

**

JUN 13 2017

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

1

139192

1

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
TOS 8 1 MUL TOS 8 1 MUL WIN 8 1 MUL								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
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Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 5/8/2017

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Start Qty: 7.00

Required Qty: 7.00

D3440-9 Manufactured No

100

Each

2.0000

1

7

JUN 13 2017

**DAS
24
9-89**

D3440-9

Tube Detent Clip Base (Supersedes B67-43001-241)

Location

Loc Qty

Loc Code

Mezz2

2

139210

2

100

Each

2.0000

1

7

JUN 13 2017

**DAS
24
9-89**

D3440-13

Manufactured No

D3440-13

Bracket (Supersedes B67-43001-273)

Location

Loc Qty

Loc Code

Mezz2

2

139211

2

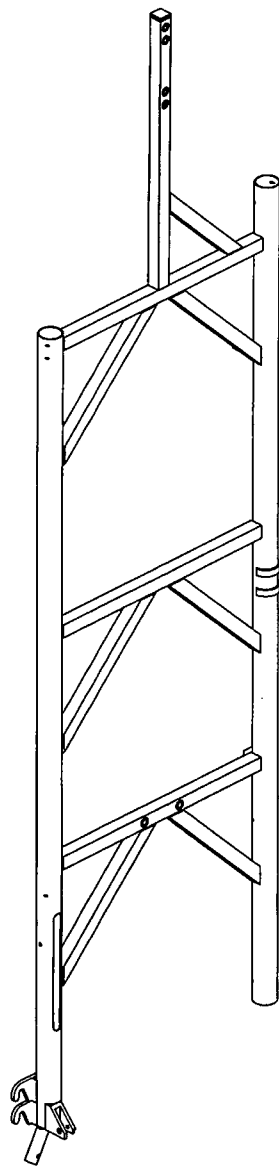
DQA: _____ Date: _____

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.452 1 14:11								Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
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OTHER : _____								



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

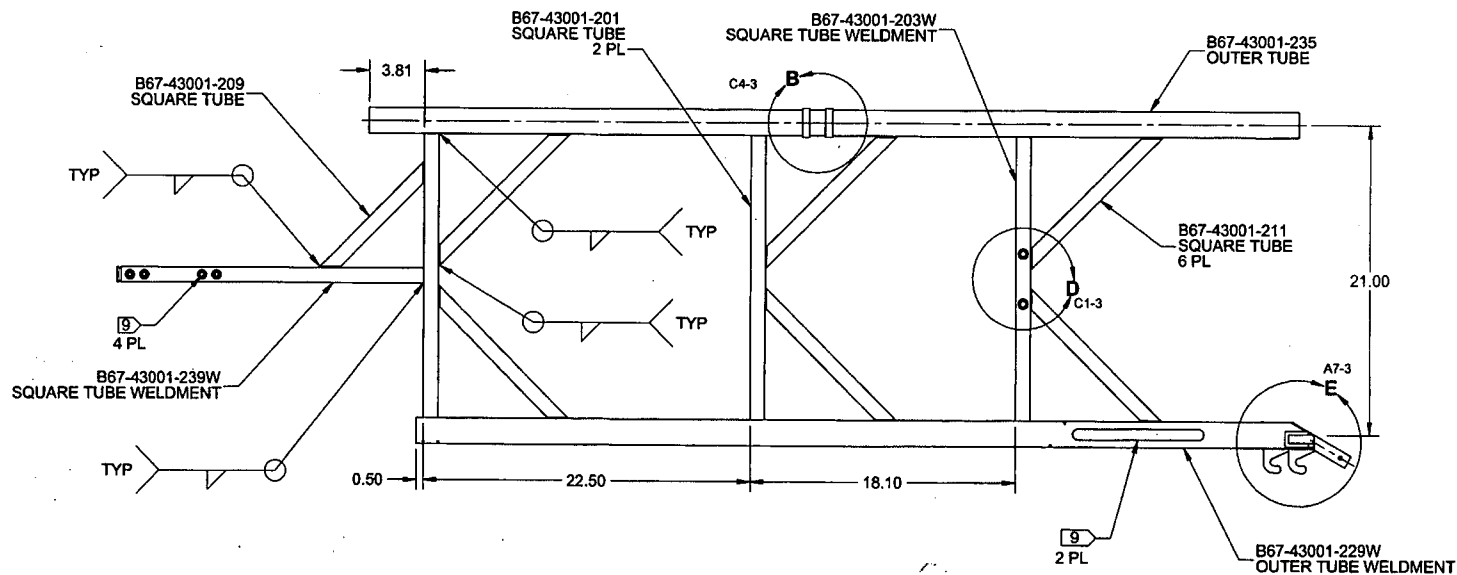
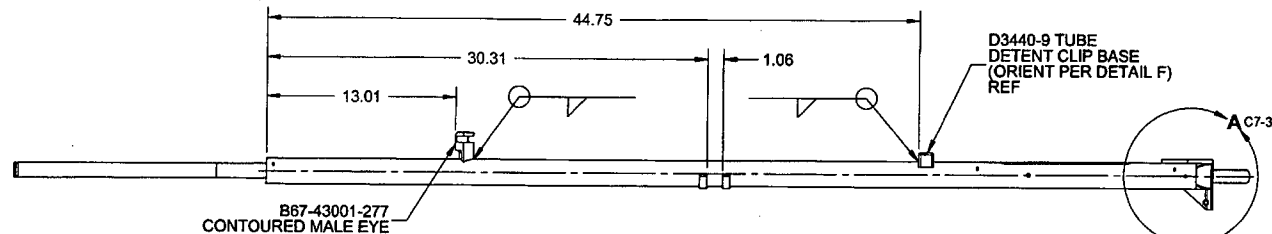
NO. 160912 MCG
170505

RELEASED
2016-11-09
EW 16-655

APPROVED

ITEM	QTY -09	P/N	DESCRIPTION
	X	B67-43001-09	AFT BLADE FOLD ASSEMBLY WELDMENT
1	2	B67-43001-201	SQUARE TUBE
2	1	B67-43001-203W	SQUARE TUBE WELDMENT
3	1	B67-43001-209	SQUARE TUBE
4	6	B67-43001-211	SQUARE TUBE
5	2	B67-43001-213	FLANGED HOOK
6	1	B67-43001-229W	OUTER TUBE WELDMENT
7	1	B67-43001-235	OUTER TUBE
8	1	B67-43001-239W	SQUARE TUBE WELDMENT
9	1	B67-43001-243	TUBE HANDLE EXTENSION
10	1	B67-43001-277	CONTOURED MALE EYE
11	2	B67-43001-311	RESTRAINT
12	1	D3440-9	TUBE DETENT CLIP BASE
13	1	D3440-13	FLANGE HOOK

E	REMOVE MASKING INSIDE HOOK AREA ON B67-43001-213 (ZNA7-3) VERIFIED MATERIAL SPECIFICATIONS: WEIGHT AFFECTED (ZNA8-2) REASON PAR15-437	SAD	16.10.18
D	REVISE BOM AND ANNOTATIONS TO INCORPORATE -203W/-229W/-239W WELDMENTS, DELETE DETAIL C (SH 2, 3); REASON: TO FACILITATE MANUFACTURING	DB	14.07.24
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 6 OF PREMIER AVIATION DRAWING #B67-43001 REASON: SEE PAR09-011	MB	10.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	B67-43001-09	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
DATE	16.10.18	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 11.40 lbs
- 8) WELDING: PER QSI 004
- 9) MASKING: ALL OPENINGS AND INDICATED AREAS PRIOR TO POWDER COATING

RELEASED
2016-11-09

APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	B67-43001-09	SHEET 2 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
DATE	16.10.18	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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MATE WITH TOP SURFACE OF
LOWER HOOK AND ALIGN WITH
CENTERLINE OF OUTER TUBE

ALIGN WITH BOTTOM
EDGE OF END CAP AND
CENTERLINE OF OUTER TUBE

ALIGN WITH CENTERLINE
OF OUTER TUBE AND FLUSH
WITH ANGLED CUT

B67-43001-243 [9]
TUBE HANDLE EXTENSION
REF

D3440-13
BRACKET

ALIGN WITH CENTERLINE OF
OUTER TUBE AND TO BOTTOM
SURFACE OF END CAP

DETAIL A D3-2
SCALE 4X

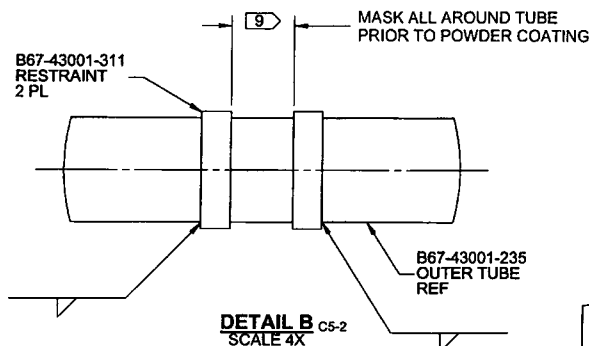
B67-43001-229W
OUTER TUBE WELDMENT OUTER TUBE WELDMENT
REF

MASK INSIDE SURFACES
OF BRACKET PRIOR
TO POWDER COATING

B67-43001-243 [9]
TUBE HANDLE EXTENSION

B67-43001-213
FLANGED HOOK
2 PL

DETAIL E B3-2
SCALE 4X



B67-43001-203W
SQUARE TUBE WELDMENT
REF

B67-43001-211
SQUARE TUBE
REF

DETAIL D B4-2
SCALE 4X

MASK INSIDE SURFACE AND
HOLE (NOT SHOWN) OF
CONTOURED MALE EYE
PRIOR TO POWDER COATING

D3440-9 TUBE DETENT CLIP BASE [9]
MASK THREADED HOLE (NOT SHOWN)
PRIOR TO POWDER COATING

DETAIL F C2-2
SCALE 4X

RELEASED
2016-11-09

APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	B67-43001-09	SHEET 3 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
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